

Work Order ID 136063

Thursday, August 27, 2015 2:39:29 PM

136063

Page 1

Item ID: D3011-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Rappel Slide Bar
 Start Date: 8/27/2015 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 8/27/2015 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: AUG 27 2015 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3011	C

100	BAND SAW	0.00				4	0		<i>mf</i> 15/10/19
100									
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	Cut Blanks: 26.625"								

110	HAAS CNC VERTICAL MACHINING #1	0.01				4	0		<i>mf</i> 15/10/22
110									
HAAS 1	Memo	0.04							
HAAS CNC vertical machine #1	Machine as per folio FA129								
	Folio Rev: <u>AA</u>								
	Dwg Rev: <u>C</u>								

***ENSURE SURFACES ARE SMOOTH, BUFF ALL SCRATCHES AS
 REQUIRED AS PER NOTE 11 DWG D3011***

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC2- Inspect parts off machine FAI/FAIB	0.00				4	0		15/10/22
120									
QC	Memo	0.00							
Quality Control									
130	QC8- Inspect parts - second check	0.00				4	0		DAS 20 9-89 15-10-27
130									
QC	Memo	0.00							
Quality Control									
131		0.00							
131									
Outsource2	Memo	0.00							
Outsource process - NDT	1- LPI AS PER ASTM 1417 LEVEL 2 AS PER DWG D3011 2- Certificate of conformity is required								
	P/O: 30414								

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Item ID: D3011-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Rappel Slide Bar

Start Date: 8/27/2015 Start Qty: 4.00

4

Cust Item ID:

Required Date: 8/27/2015 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run

Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

132

Receive & Inspect for Damage & Mat'l Certs

0.00

132

Packaging

Memo

0.00

Packaging

4x SPIS-11-12

135

QC5- Inspect part completeness to step on W/O

0.00

135

QC

Memo

0.00

Quality Control

(4)

DAS
38
9-89
NOV 12 2015

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

4 15-11-16

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <i>M 133454.</i> Memo START TIME: <i>11:45</i> OVEN TEMPERATURE: <i>320°</i> FINISH TIME: <i>12:15</i>	0.00 0.00				<i>4</i>	<i>6</i>	<i>15-11-16.</i>	<i>DAS 34 9-89</i>
160 *160* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<i>(4)</i>			<i>DAS 38 9-89</i> <i>NOV 17 2015</i>
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: <i>S374</i> Memo	0.00 0.00				<i>4</i>		<i>NOV 19 2015</i>	<i>11-11</i>

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Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Rappel Slide Bar

Start Date: 8/27/2015 Start Qty: 4.00

4

Cust Item ID:

Required Date: 8/27/2015 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.01

Quality Control

MLJ NOV 19 2015

MLJ NOV 19 2015

Picklist Print

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Page 1

Work Order ID: 136063

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Parent Item: D3011-1

D3011-1

Parent Item Name: Rappel Slide Bar

Start Date: 8/27/2015

Required Date: 8/27/2015

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP C02.05.09Added D6202 at step 2NG
IPP Rev:D Added QC8 JLM Verified By:EC
REV:E 13.06.26 AS PER DWG REV.C DD VERF:JFS

IPP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6202		Manufactured	No			110	f	14.0000	2.1666	9.122526			

D6202

I-Beam Extrusion

Location

Loc Qty

Loc Code

MAT028

14

115132

14

9.13 *on 15/10/19*

DART AEROSPACE LTD		Work Order: 136063
Description: Rappel Slide Bar		Part Number: D3011-1
Inspection Dwg: D3011-1 Rev: C		Page 1 of 1

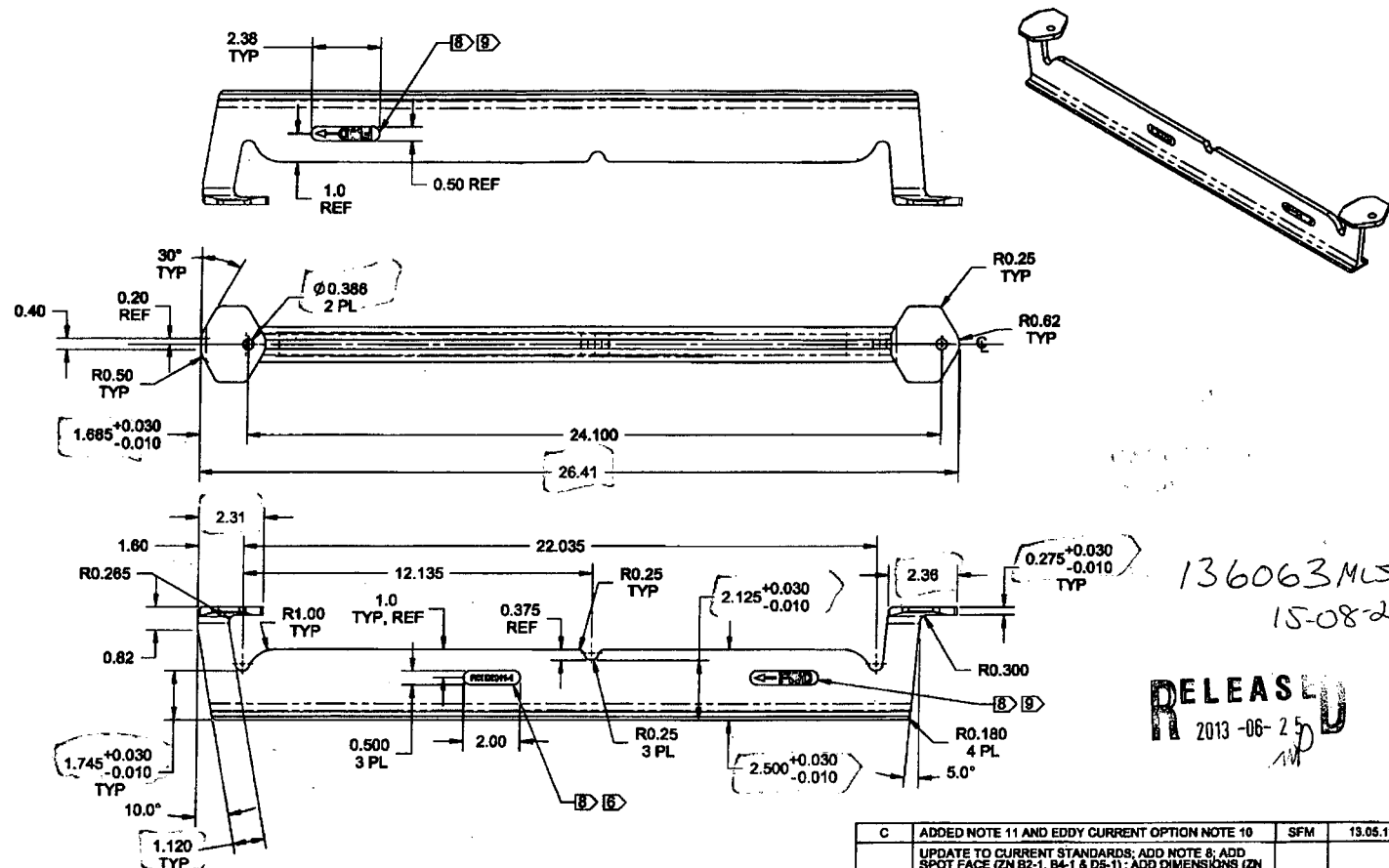
FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
26.41	+/-0.030	26.410	✓		MIP-04	vern
2.31	+/-0.030	2.309	✓		...	...
2.36	+/-0.030	2.360	✓			
1.120	+0.030/-0.010	1.122	✓			
1.685	+0.030/-0.010	1.685	✓			
1.745	+0.030/-0.010	1.757	✓			
1.250	+0.030/-0.010	1.272	✓			
2.500	+0.030/-0.010	2.508	✓			
2.125	+0.030/-0.010	2.136	✓			
0.275	+0.030/-0.010	0.288	✓			
0.375	REF	0.370	✓		MIP-08	Dist depth gage
Ø0.386	+0.006/-0.001	0.388	✓		MIP-04	vern

Measured by: <i>[Signature]</i>		DAS 20 9-89		Preliminary Approval:	
Date: 15/10/22		Date: 15-10-27		Date:	

Rev	Date	Change	Revised by	Approved
A	09.05.04	New Issue	KJ/DD	
B	09.09.14	Dimensions revised per Dwg Rev B	KJ	
C	13.07.18	Dwg Rev updated	KJ <i>[Signature]</i>	<i>[Signature]</i>

8 7 6 5 4 3 2 1



136063 M5
15-08-27

RELEASED
2013-06-25

NOTES:

- 1) MATERIAL: MANUFACTURE FROM D6202-027 EXTRUSION
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N IN THIS AREA AS SHOWN (NEAR SIDE ONLY) TO MAX DEPTH OF 0.015 IN 0.19 HIGH LETTERS WITH A MIN RADIUS TOOL OF 0.015
- 7) WEIGHT: 3.00 lbs
- 8) SPOT FACE MAX DEPTH OF 0.010 PRIOR TO MARKING
- 9) ENGRAVE "FWD" IN THIS AREA AS SHOWN TO MAX DEPTH OF 0.015 IN 0.38 HIGH LETTERS WITH MIN TOOL RADIUS OF 0.015
- 10) LPI PER ASTM 1417 LEVEL 2 OR EDDY CURRENT BY AN NAS 410 LEVEL 2 MINIMUM CERTIFIED/QUALIFIED PERSONNEL.
- 11) ENSURE SURFACES ARE SMOOTH, BUFF ALL NICKS/SCRATCHES/GOUGES AS REQUIRED.

D3011-1 RAPPEL SLIDE BAR

C	ADDED NOTE 11 AND EDDY CURRENT OPTION NOTE 10	SFM	13.05.13
B	UPDATE TO CURRENT STANDARDS; ADD NOTE 8; ADD SPOT FACE (ZN B2-1, B4-1 & D5-1); ADD DIMENSIONS (ZN B3-1, B4-1 & C5-1); 26.41 WAS 26.32 (ZN C4-1); 2.70 WAS 2.700 (ZN B7-1); ADD (+0.030/-0.010) TOLERANCES; ADD LPI (ZN A8-1)	RF	09.07.24
A	NEW ISSUE	CP	01.03.29
REV.	DESCRIPTION	BY	DATE
DESIGN	DS		
DRAWN	SFM		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	13.05.13		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3011
REV. C
SHEET 1 OF 1
SCALE NTS

TITLE RAPPEL SLIDE BAR
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DART
AEROSPACE

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO30414**

Purchase Order Date 11/11/2015

PO Print Date 11/12/2015

Page Number 7 of 8

Order From :

SKYSERVICE
6120 MIDFIELD ROAD
MISSISSAUGA, ONTARIO L5P 1B1
CANADA

VC-SKY001

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone

905-678-5636

Ship To Contact

Ship To Phone

Ship Via:

Delivered

Ship Acct:

Buyer

Customer POID

Customer Tax #

Terms

Currency

FOB

Chantal Lavoie

10127-2607

Net 30

CAD

FCA - (Free Carrier)

Line Total:

\$96.50

18 130375

D212-664-201
CROSSTUBE

11/12/2015

1.00

\$96.50

\$96.50

Yes

11/12/2015

SAME AS ABOVE

Line Total:

\$96.50

19 130376

D212-664-201
CROSSTUBE

11/12/2015

1.00

\$96.50

\$96.50

Yes

11/12/2015

SAME AS ABOVE

Line Total:

\$96.50

20 136063

D3011-1 RAPPEL SLIDE
BAR

11/12/2015

4.00

\$24.13

\$96.50

Yes

11/12/2015

SAME AS ABOVE

Note:

11/12/2015

8815-11-12

**skyservice****Work Order Traveler**

Sky Service F.B.O. Inc.

DOT APP 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO26386	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: 30414
Descr:	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN:	CSN:	TSO:	
Task: UNSCHEDULED			Sequence: 1

Work Required:

CARRY OUT NDT ON 18 CROSSTUBES AND 4 RAPPEL SLIDE BARS AS PER PO30414

4 RAPPEL SLIDE BARS, ITEM ID# D3011-1, WORK ORDER ID# 136063

8 FWD CROSSTUBES, ITEM ID# D212-664-101, WORK ORDER ID# 138548, 136075, 138547, 138549, 138551, 138614, 138550, 138615

7 AFT CROSSTUBES, ITEM ID# D212-664-201, WORK ORDER ID# 136085, 136081, 136083, 130376, 136082, 136084, 130375

3 FWD CROSSTUBES, ITEM ID# D206-667-101, WORK ORDER ID# 135128, 135129, 135130

Action Taken:						Date:	Initial/Stamp:
LPI C/O IAW ASTM E-1417M13 NO CRACK FOUND PEN. ZL-56, MPO13600, UV M-20141, CLEANER SKC-S MPO13923 , DEV. MPO11715						NOV 11 2015	
Description	Location	P/N	Qty	Batch	S/N Off	S/N On	

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature:	ACA/SCA Stamp 	Date: NOV 11 2015
Name: DAVID DELIRIAN		